

# Work Order ID 84806

May-23-12 11:32:31 AM

**\*84806\***

Page 1

Item ID: D206-628-012

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Heli-Access-Step RH

Start Date: 23/05/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 06/06/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/05/23

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

N/A

Rev N/A

*\* SP -*

100

0.00

**\*100\***

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels as per PPP D206-628-012 CHG 003

*5/21/10*

110

Pick Kit

0.00

**\*110\***

Packaging

Memo

0.00

Packaging

*4*

*12/02/06 JB*

120

QC4- 100% Inspect kits for completeness

0.00

**\*120\***

QC

Memo

0.00

Quality Control

*5/21/10*

*24  
RM*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 84806

May-23-12 11:32:31 AM

**\*84806\***

Page 2

Item ID: D206-628-012

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Heli-Access-Step RH

Start Date: 23/05/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 06/06/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00				4x			SP
<b>*130*</b>									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-628-012 Location: _____ PPP Rev: <u>F</u>								12-7-10
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							CK 12/7/11
Quality Control									

12-7-11

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 1

May-23-12 11:32:35 AM

Work Order ID: 84806

\*84806\*

Parent Item: D206-628-012

\*D206-628-012\*

Parent Item Name: Heli-Access-Step RH

Start Date: 23/05/2012

Required Date: 06/06/2012

Start Qty: 4.00

Required Qty: 4.00

## Comments:

IPP Rev:D As Per Ecn 766 06-01-06 JLM  
 IPP rev E changed D2731-1 to D2731-3 EC  
 IPP Rev:F as per ecn 1118 08-02-05 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2721-042		Manufactured	No			110	Each	0.0000	1	4			
<b>*D2721-042*</b>													
206B Step Assembly													
D2731-7		Manufactured	No			110	Each	72.0000	4	16			
<b>*D2731-7*</b>													
Mounting Lug													

*S.M.* **\*D2732-030\***

Rubber Cushion

*on 88 per kit*

*3.01*

*→ measure 8/17/06*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

May-23-12 11:32:35 AM

Page 2

Work Order ID: 84806

\*84806\*

Parent Item: D206-628-012

\*D206-628-012\*

Parent Item Name: Heli-Access-Step RH

Start Date: 23/05/2012

Required Date: 06/06/2012

Start Qty: 4.00

Required Qty: 4.00

D3394-043

Manufactured No

110 Each

112.0000 4 16

\*D3394-043\*

Lug Assembly

\*\*

JB

## Location

## Loc Qty

## Loc Code

ST479

112

78921

32

80217

60

82760

20

78921

AN4-13A

Purchased No

110 Each

1,513.000 4 16

\*AN4-13A\*

Bolt

\*\*

JB

## Location

## Loc Qty

## Loc Code

ST357

1513

119449

33

120187

19

120422

2

120770

394

121162

65

121652

1000

121652

AN4-14A

Purchased No

110 Each

344.0000 4 16

\*AN4-14A\*

Bolt

\*\*

JB

12/07/06

## Location

## Loc Qty

## Loc Code

357

100

121349

100

ST357

244

120187

13

120769

1

121068

17

121444

100

121708

113

121349

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



# Picklist Print

May-23-12 11:32:35 AM

Page 3

Work Order ID: 84806

\*84806\*

Parent Item: D206-628-012

\*D206-628-012\*

Parent Item Name: Heli-Access-Step RH

Start Date: 23/05/2012

Required Date: 06/06/2012

Start Qty: 4.00

Required Qty: 4.00

AN4-15A

Purchased

No

110

Each

591.0000

16

\*AN4-15A\*

Bolt

\*\*

122141

JB

Location

Loc Qty

Loc Code

358

100

121652

100

GA

100

120449

100

ST358

391

118706

3

120422

88

121444

100

121541

200

AN960JD416

NAS1149D0463J

Purchased

No

110

Each

30.0000

48

\*AN960JD416\*

Washer

\*\*

121912

JB

Location

Loc Qty

Loc Code

ST351

30

116289

10

119097

20

MS21042L4

Purchased

No

110

Each

4,414.000

48

\*MS21042L4\*

Nut

\*\*

JB

12/07/06

Location

Loc Qty

Loc Code

ST300

4414

119075

125

121011

1032

121444

2957

121652

300

121444

May-23-12 11:32:35 AM

Shop Packet Print

Page 3

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

### 5.1 D206-628-011/-012/-021/-022/-031/-032 REGULAR DART HELI-ACCESS- STEPS™ PARTS LIST

Qty -011	Qty -012	Qty -021	Qty -022	Qty -031	Qty -032	Part Number	Description
X						D206-628-011	206 A/B STEP INSTALLATION LH
	X					D206-628-012	206 A/B STEP INSTALLATION RH
		X				D206-628-021	206 L/L1/L3/L4 STEP INSTALLATION LH
			X			D206-628-022	206 L/L1/L3/L4 STEP INSTALLATION RH
				X		D206-628-031	407 STEP INSTALLATION LH
					X	D206-628-032	407 STEP INSTALLATION RH
1						D2721-041	STEP ASSEMBLY LH
	1					D2721-042	STEP ASSEMBLY RH
		1		1		D2724-041	STEP ASSEMBLY LH
			1		1	D2724-042	STEP ASSEMBLY RH
				4	4	D2731-3	MOUNTING LUG
4	4	4	4			D2731-7	MOUNTING LUG
8	8	8	8	8	8	D2732-030	RUBBER CUSHION
				4	4	D3394-041	MOUNTING LUG
				4	4	*D3394-1	*MOUNTING LUG
				8	8	*MS35489-93	*GROMMET
4	4	4	4			D3394-043	MOUNTING LUG
4	4	4	4			*D3394-3	*MOUNTING LUG
8	8	8	8			*MS35489-93	*GROMMET
4	4			4	4	AN4-13A	BOLT
4	4	4	4	4	4	AN4-14A	BOLT
4	4	8	8	4	4	AN4-15A	BOLT
12	12	12	12	12	12	NAS1149D0463J	WASHER (AN960JD416)
12	12	12	12	12	12	MS21042L4	NUT (OR MS21042-4)

\*DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE

RELEASED  
05.11.14

APPLY BLACK  
ANTI-SKID ON  
- TOP SURFACE  
TO BOTTOM  
OF TOP RADIUS

REFER TO STEP  
END DETAIL

D2721-1  
MAKE FROM EXTRUSION D2622-078

D2721-041 LH STEP ASSEMBLY (SHOWN)  
D2721-042 RH STEP ASSEMBLY (OPPOSITE)

ROUND CORNER OF EXTRUSION TO  
MATCH BEND RADIUS OF END PLATE

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D2721-041	LH STEP ASSEMBLY
	X	D2721-042	RH STEP ASSEMBLY
1	1	D2622-078	EXTRUSION
2	2	D2734	END PLATE
1	1	D3461-1	PLATE
1	1	D3461-3	PLATE
1	1	D3461-5	PLATE
1	1	D3461-7	PLATE

1) MAKE FROM EXTRUSION D2622

2) WELD PER DART QSI 004

3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

4) ALL DIMENSIONS ARE IN INCHES

5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

TYPICAL STEP END DETAIL

DESIGN	PH	APPROVED	DRAWING NO.	REV. C
			D2721	SHEET 1 OF 1
DATE	05.09.19		TITLE	SCALE
			206B STEP ASSEMBLY	NTS
A	97.12.04		NEW ISSUE	
B	98.10.19		79" WAS 80", UPDATED WELD DETAIL REVISED TOLERANCES, 53.44 WAS 54.0	
C	05.09.19		RE-DESIGN, ADD D3461-1/-3/-5/-7	

**Copyright © 2005 by DART AEROSPACE USA, INC.**  
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.